

Work Order ID 78899***78899***

Page 1

January-17-12 8:11:57 AM

Item ID: D3948-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate, Anchor

Start Date: 1/17/12 Start Qty: 6.00

6

Cust Item ID:


Required Date: 1/19/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3948

B

100

0.00

100

Waterjet

FLOW CNC Waterjet

6061 .063


Memo

1-Cut as per Dwg. D3948-1

Dwg Rev: BProg Rev: B

2-Deburr if necessary

0.00

 12/02/15

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00


110

QC

Quality Control

Memo

0.00

 12/02/15

6

Work Order ID 78899

78899

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N900040100

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Stop ***NS2***

Item Name: Plate, Anchor

Start Date: 1/17/12 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 1/19/12 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120		0.00							
QC	Memo								
Quality Control									
130		0.00							
130		0.00							
Small Fab	Memo								
Small Fab	1- countersink holes as per dwg								
	2- deburr if necessary								
140	QC5- Inspect part completeness to step on W/O	0.00							
140		0.00							
QC	Memo								
Quality Control									

SP 12/02/15

6

SP 12/02/15 6

SP 12/02/15

6

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January-17-12 8:11:57 AM

Item ID: D3948-041

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate, Anchor

Start Date: 1/17/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/19/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

12-2-17 (6)

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

12/22/21 (6)

170

Pick Kit

0.00

170

Packaging

Memo

0.00

Packaging

12/22/21 (6)

Work Order ID 78899***78899***

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January-17-12 8:11:57 AM

Item ID: D3948-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate, Anchor

Start Date: 1/17/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/19/12

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00

180

Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AS PER DWG

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: 574

0.00

200

Packaging

Memo

0.00

Packaging

12/02/11 (6)

12.02.21 (6)

12/21 (6)

Work Order ID 78899***78899***

Page 5

January-17-12 8:11:57 AM

Item ID: D3948-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate, Anchor

Start Date: 1/17/12 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 1/19/12 Req'd Qty: 6.00 ***6***

Customer:

Reference:

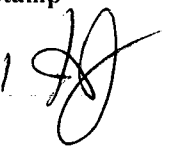
Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12/2/21 pl 12-01-21
(4)

Picklist Print

January-17-12 8:11:57 AM

Page 1

Work Order ID: 78899

Parent Item: D3948-041

Parent Item Name: Plate, Anchor

Start Date: 1/17/12

Required Date: 1/19/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	354.0696	0.1085	0.6852632			

Location Loc Qty Loc Code

MAT021 354.0695684
113608 0
116308 11.9555684
117285 75.414
119331 49.2
119802 25.5
120278 192

MS21059L3

Nut Plate

Purchased

No

170

Each

123.0000

2

12

Location Loc Qty Loc Code

ST301 123
118614 23
119546 100

MS20426AD3-3

Rivet

Purchased

No

170

Each

3,315.0000

4

24

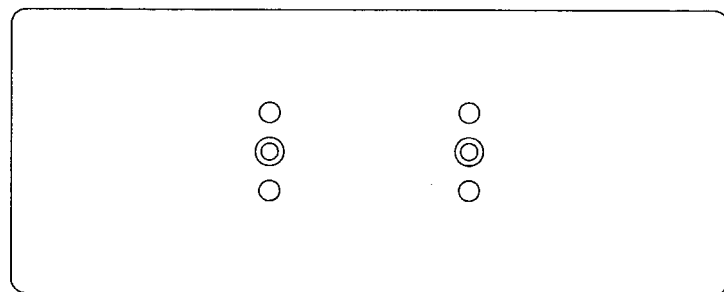
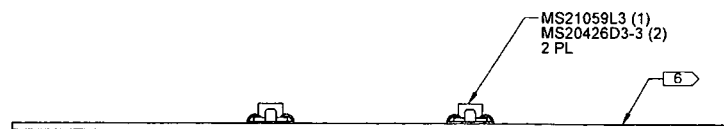
Location Loc Qty Loc Code

ST316 3315
119109 2812
19099 503

12/02/15
12/02/21
12/02/21
24

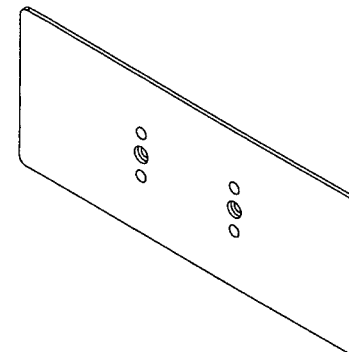
PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET

**D3948-041 PLATE, ANCHOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

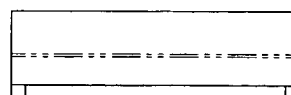
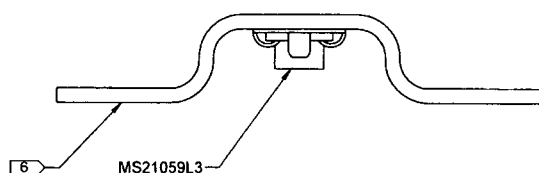
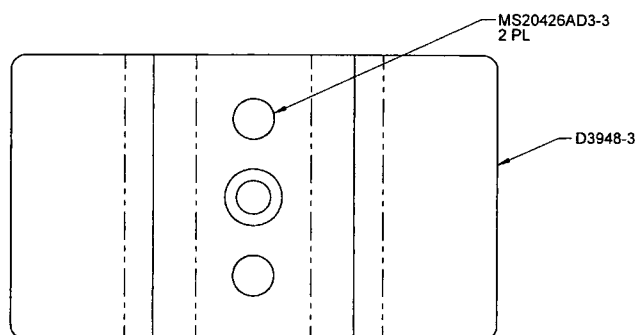
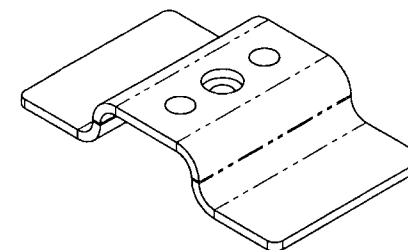


B	-3F NOW MADE FROM 304 SS (ZN A8-5), 0.063 THICK WAS 0.040 (ZN A8-3, A8-5), -043/-3/-3F WIDER (ZN B6-4, B6-5)	CP	09.06.08
A	NEWISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	931		
DRAWN	931		
CHECKED	213		
MFG. APPR.	213		
APPROVED	213		
DE APPR.	213		
DATE	09.06.08		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3948	REV. B SHEET 1 OF 5
TITLE PLATE, ANCHOR	
SCALE NTS	
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PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-043	PLATE, ANCHOR
2	1	D3948-3	PLATE
3	1	MS21059L3	NUTPLATE (OR MS21059-3)
4	2	MS20426AD3-3	RIVET



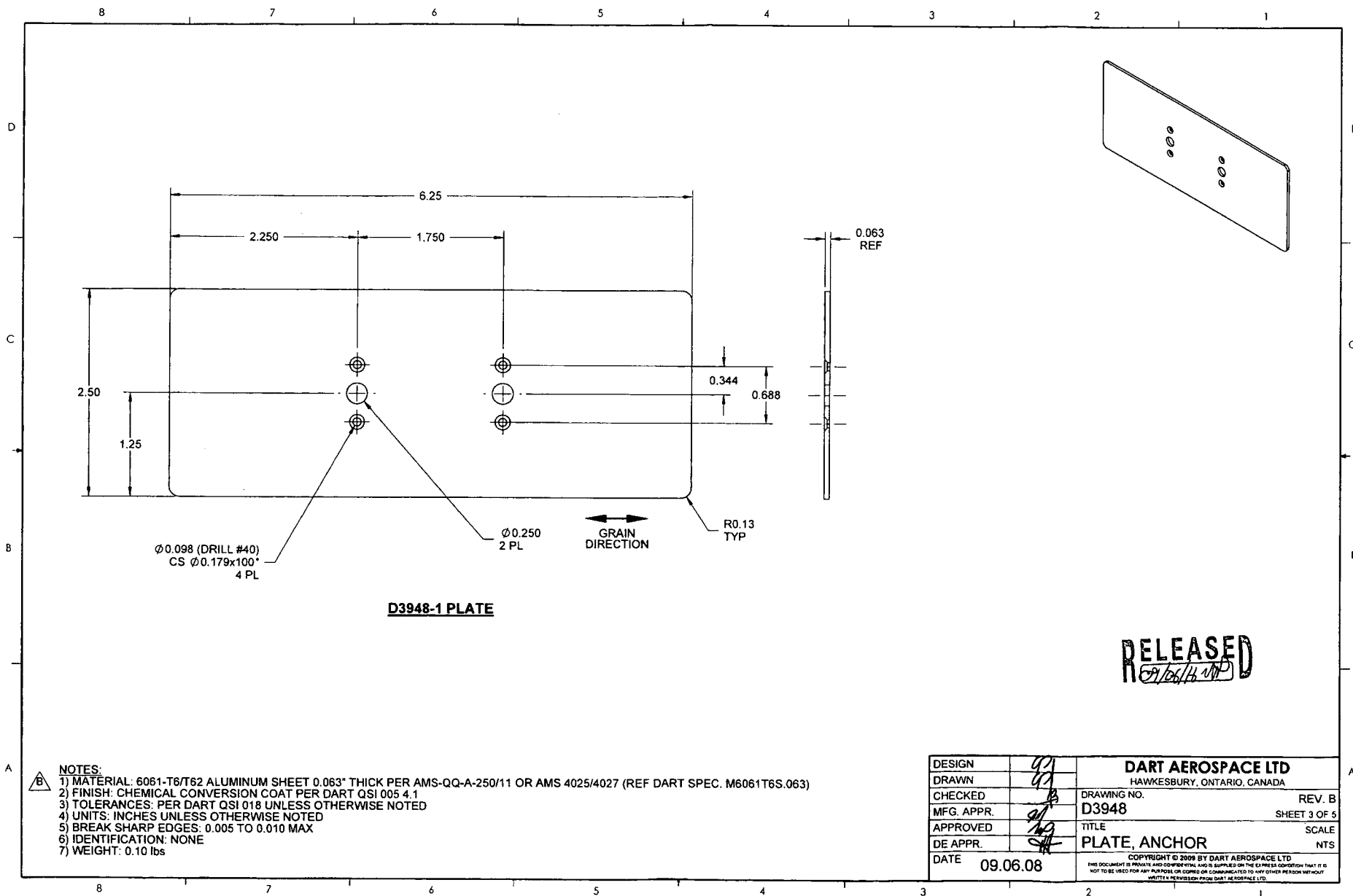
D3948-043 PLATE, ANCHOR

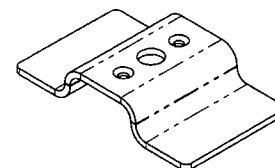
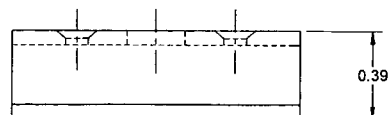
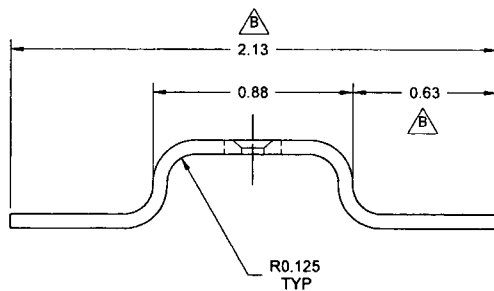
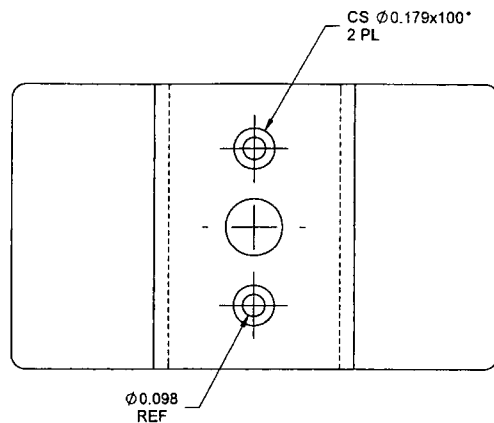
RELEASED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

DESIGN	91	DART AEROSPACE LTD	
DRAWN	91	HAWKESBURY, ONTARIO, CANADA	
CHECKED	91	DRAWING NO.	REV. B
MFG. APPR.	91	D3948	SHEET 2 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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D3948-3 PLATE

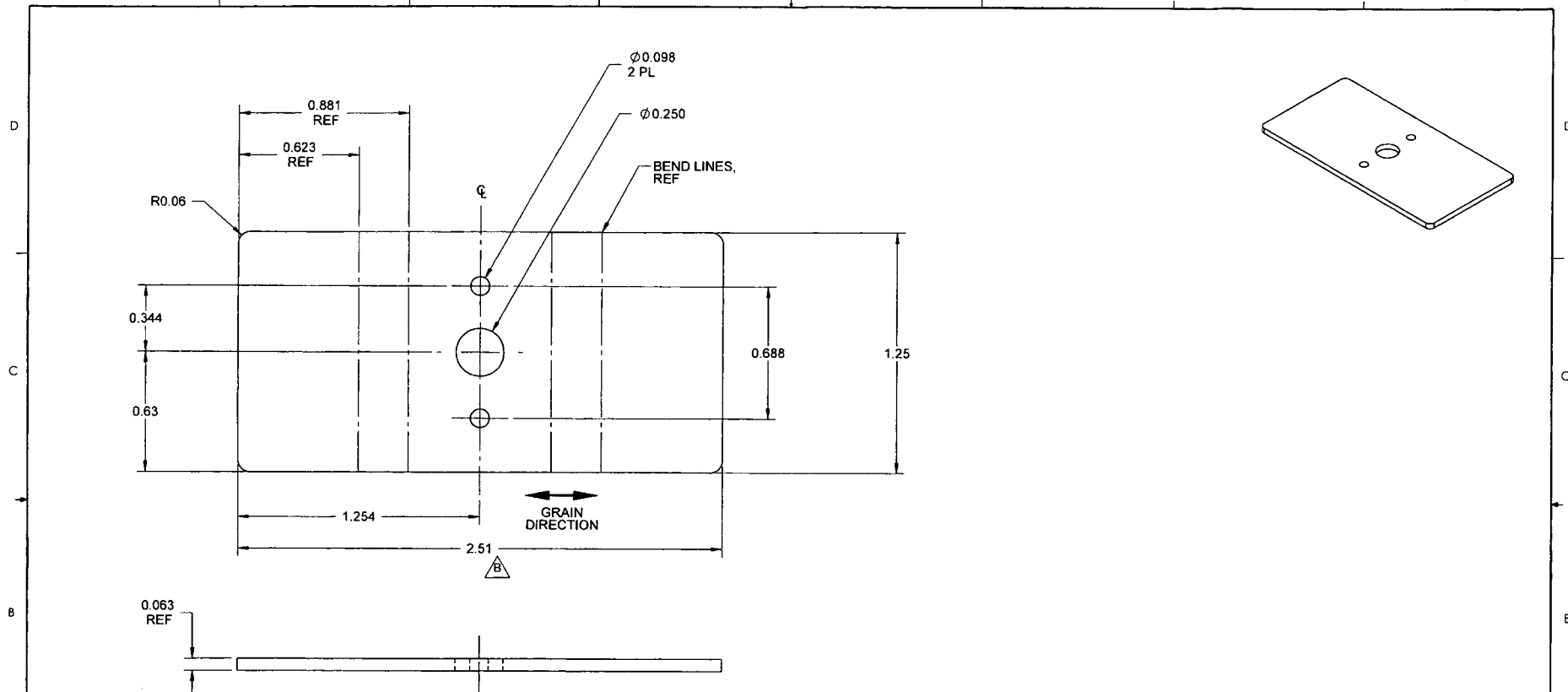
RELEASED
09/06/08

NOTES:

- 1) MATERIAL: MAKE FROM D3948-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. B
MFG. APPR.	92	D3948	SHEET 4 OF 5
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DE APPR.	92	PLATE, ANCHOR	NTS
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8 7 6 5 4 3 2 1



D3948-3F PLATE

RELEASED
9/16/16

- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET 0.063" THICK (REF DART SPEC. M304S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. B
MFG. APPR.	92	D3948	SHEET 5 OF 5
APPROVED	92	TITLE	SCALE
DE APPR.	92	PLATE, ANCHOR	NTS
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8 7 6 5 4 3 2 1